

543

DART AEROSPACE LTD		Work Order:	23318
Description: Heli Access Step LH (206L)		Part Number:	D206-628-021
Dwg:		Qty:	3
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Travelers for: D206-628-021 Heli Access Step LH D2724-041 Step Assembly LH		05.10.03	3																																								
2	DC	Photocopy bluefile and create labels per PPP D206-628-021 CHG001	DT	05-10-20	3																																								
3	ST	Pick: Packing Kit <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2724-041</td> <td>Step Assembly LH</td> <td>B 23318</td> </tr> <tr> <td>4</td> <td>D2731-5</td> <td>Mounting Lug</td> <td>B 20615</td> </tr> <tr> <td>4</td> <td>D2731-7</td> <td>Mounting Lug</td> <td>B 20616</td> </tr> <tr> <td>4</td> <td>AN4-11A</td> <td>Bolt</td> <td>M15 057</td> </tr> <tr> <td>4</td> <td>AN4-12A</td> <td>Bolt</td> <td>M18 037</td> </tr> <tr> <td>4</td> <td>AN4-13A</td> <td>Bolt</td> <td>M17997</td> </tr> <tr> <td>12</td> <td>AN960JD416</td> <td>Washer</td> <td>M17566</td> </tr> <tr> <td>12</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M17492</td> </tr> <tr> <td>1</td> <td colspan="3">Copy of paperwork from step 2</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2724-041	Step Assembly LH	B 23318	4	D2731-5	Mounting Lug	B 20615	4	D2731-7	Mounting Lug	B 20616	4	AN4-11A	Bolt	M15 057	4	AN4-12A	Bolt	M18 037	4	AN4-13A	Bolt	M17997	12	AN960JD416	Washer	M17566	12	MS21042L4	Nut (or -4)	M17492	1	Copy of paperwork from step 2				05/1/28	3
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1	Copy of paperwork from step 2																																												
4	QC4	Inspect Kit 100% for Completeness on the W/O	CL	05/10/28	3																																								
5	PK	Identify and pack for shipping as per PPP D206-628-021	Rev. D	05/1/28	3																																								
6	AC	Cost / part: 198.84	SUC	05-11-01	3																																								
7	DC	Close W/Order and Ensure Travellers Attached Inspect Level 21 / 98.84 Travellers: D206-628-021 D2724-041	LD	05/10/31	3																																								

Rev	Date	Change	Revised By	Approved
A	98.04.16	New Issue		
B	99.02.05	Reformat	DM	
C	04.05.17	Reformat; Added D2724-041 as traveler	KJ/JLM	04.05.25

RCP0000753

RELEASED
04.05.25

UNDER REVIEW

04.09.14

OK to sell existing
stock

05.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05/10/31

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023318
Project Name : *D206-628-021
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : *D206-628-021
Description : Heli-Access-Step LH
Manufactured : Yes
Amount Req'd : 3
Amount Done : 0
Start Date : 05-16-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD.	Work Order :	23318
Description: 206L / 407 Step Assy, LH	Part Number:	D2724-041
Drawing: D2724 Rev. B	Qty:	3

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	PA	05.10.03	3
2	METAL	Cut D2724-1 using D2622 extrusion as per Dwg D2724 Batch No. 1323612	PD	05.10.17	3
3	METAL	Deburr and bevel ends for welding	PD	05.10.18	3
4	STORES	Pick: Qty Part Number Description Batch 2 D2734 End Cap 050151 2 D2725 Lug 050183	PD	05.10.18	3
5	QC	Inspect for foreign object per QSI 024	PD	05.10.18	3
6	WELDING	Weld end caps and lugs as per Dwg D2724 using Jig DT 8130 followed by Jig DT 8134	PD	05.10.18	3
7	METAL	Grind end cap welds flush	PD	05.10.18	3
8	QC	Inspect Level 9	PA	05.10.18	3
9	QC	Inspect Level 5	PA	05.10.25	3
10	FINISHING	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3	PA	05.10.26	3
11	QC	Inspect Level 3	CL	05.10.26	3
12	METAL	Wing Walk per Dwg 2724 and QSI 005 4.4	PA	05.10.26	3
13	QC	Inspect Level 3	CL	05.10.28	3
14	STORES	Bag and tag	CL	05.10.28	3
15	EXPEDITING	Close W/O Cost / Part	DP	05.10.31	3

Rev	Date	Change	Revised By	Approved
A	98.04.16	New Issue	KB	
B	98.09.30	Reorder, Update Inspections	CP	
C	98.11.23	Added Inspections	DM	
D	00.07.20	Added Inspection for QSI 024	EC	
E	00.11.01	Removed P/O for powder coat - in house process	EC	

RELEASED

DEC 18 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

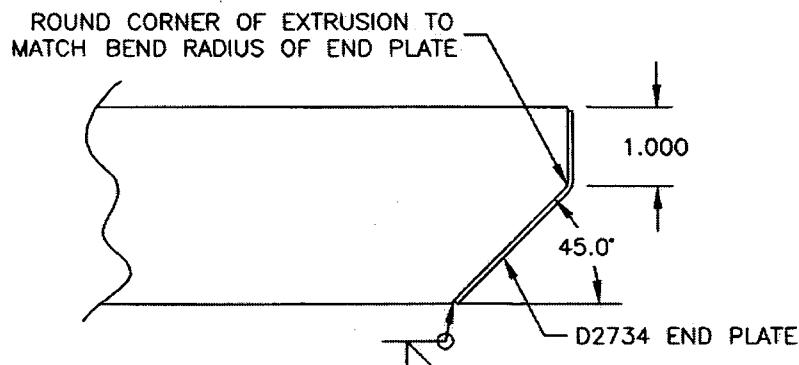
DART



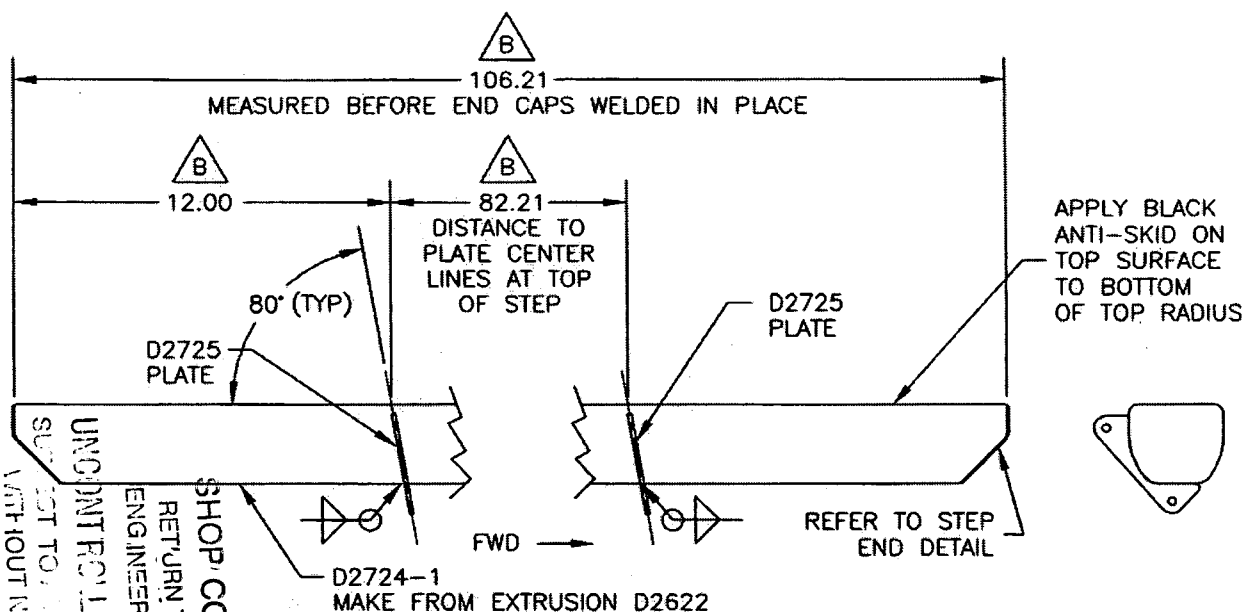
RELEASED
98.11.11 ICE

DESIGN	✓	DRAWN BY	✓	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	✓	APPROVED	✓	DRAWING NO. D2724
DATE	98.10.19	TITLE	206L/407 STEP ASSEMBLY	REV. B
A	97.12.04	NEW ISSUE		SHEET 1 OF 1
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES		SCALE NTS

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO COMMENT
WITHOUT NOTICE

WORK ORDER

NO. _____